

Tuesday, October 23, 2012 4:08:24 PM

Item ID: PB67-43001-63

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Handle Assembly

Stop *NS2*

Start Date: 10/23/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 11/2/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: Process Plan: *MJS*

Date: 12-10-25 Tooling:

Date:

Run Start *NR1*

QC:

Date: _____ **SPC (Y/N):** _____

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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[illegible]

100

0.00

100

Large Fab

0.00

Large Fab

Large Fab

Memo

- 1- chamfer both ends (0.090") on -129 and -127
- 2- chamfer (0.090") only the angle end on -157
- 3- drill #40 hole in center of -129 before welding -131 caps, to let air out
- 4- weld -131 to -129 as per dwg
- 5- grind weld flush
- 6- assemble -127 under the pilot hole in -129 and -157 weld as per dwg
- 7- grind weld flush
- 8- install rivet as per dwg
- 9- assemble by drilling thru both -157 and -133 as per dwg
- 10- install spring slotted pin as per dwg

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

OC

Memo

0.00

Quality Control

4

☒

12-11-2

DAS
18
2-89

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 92099

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92099

Page 2

Item ID: PB67-43001-63 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Handle Assembly
 Start Date: 10/23/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 11/2/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 12/12/12				4			
130 *130* Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 Memo ****mask only -157 starting from rivet to end of -157 tube, rivet must be powder coat**** START TIME: 2:00 OVEN TEMPERATURE: 320°F FINISH TIME: 2:30	0.00 0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

m14144

4X ✓ 12/11/22

H φ 12/11/22

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY												
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92099

Page 3

Item ID: PB67-43001-63 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Handle Assembly
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 Required Date: 11/2/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>57444</u>	0.00							
150									
Packaging	Memo	0.00				4			12/11/23 JB
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							12/11/28
Quality Control									

MP
12-11-29

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
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Picklist Print

Tuesday, October 23, 2012 4:08:24 PM

Page 1

Work Order ID: 92099

Parent Item: PB67-43001-63

Parent Item Name: Handle Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-07-29 new issue DD verified by:ec
dwg EC verified by:DD
IPP rev B 10.09.30 per rev C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-129 Tube Handle		Manufactured	No	B90901 = 4		100	Each	0.0000	1	4		12.11.20	
PB67-43001-127 Handle Arm		Manufactured	No	B90900 = 4		100	Each	0.0000	1	4		12.11.20	
PB67-43001-157 Tube		Manufactured	No	B90906 = 4		100	Each	0.0000	1	4		12.11.20	
PB67-43001-131 Tube End Cap		Manufactured	No	B45710 = 2		100	Each	2.0000	2	8		12.11.20	

Location	Loc Qty	Loc Code
ST446 B90902 = 6	2	
45770	2	

* PB67-43001-133 Clevis	Manufactured	No	B90903 = 4	100	Each	0.0000	1	4		12.11.20		
240-107 SPRING SLOTTED PIN	Purchased	No		100	Each	159.0000	1	4		12.11.21		

Location	Loc Qty	Loc Code
122089 B112813	81	
122089	81	
ST400	78	
115827	78	

* CR3213-42 Cherry Rivet	Purchased	No		100	Each	1,019.0000	1	4		12.11.21		
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Location	Loc Qty	Loc Code
ST328 B116022	1000	
123301	1000	
ST331	19	
113288	19	

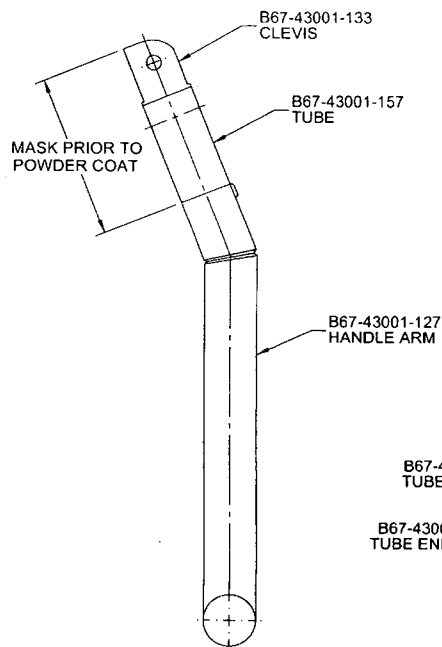
NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

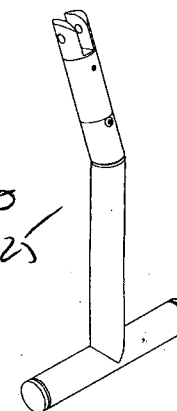
Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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B67-43001-63 SHORT T-HANDLE ASSEMBLY

ITEM	QTY -63	P/N	DESCRIPTION
1	X	B67-43001-63	SHORT T-HANDLE ASSEMBLY
3	1	B67-43001-129	TUBE HANDLE
4	1	B67-43001-127	HANDLE ARM
5	1	B67-43001-157	TUBE
6	2	B67-43001-131	TUBE END CAP
7	1	B67-43001-133	CLEVIS
9	1	MS171532	SPRING SLOTTED TENSION PIN (OR 240107)
10	1	CR3213-4-2	RIVET

UNCLASSIFIED COPY
NO. 92099-ML9
12-10-25



RELEASED
2010-09-16

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.46 lbs
- 8) WELDING: PER DART QSI 004
- 9) ALIGN B67-43001-133 AS SHOWN. ENLARGE PILOT HOLE LOCATED ON HANDLE AND DRILL THRU B67-43001-157-133. DRIVE MS171532 IN TO HOLE.

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 15 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.10
REV.	DESCRIPTION		BY	DATE
DESIGN	R/V	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-63 TITLE SHORT T-RANSFER ASSEMBLY COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	REV. C	
DRAWN			REV. C	
CHECKED			REV. C	
MFG. APPR.			REV. C	
APPROVED			REV. C	
DE APPR.	N/A		REV. C	
DATE	09.06.10		REV. C	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **B67-43001-63** REV. C
TITLE **SHORT T-HANDLE ASSEMBLY** SCALE NTS

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